

Date: Thursday, 2/7/2008 10:54:22 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	37283		Part Number	D2572		
Estimate Number	10531		Drawing Number	D2572 REV E		
P.O. Number			Project Number	N/A		
This Issue	2/7/2008	S.O. No.	Drawing Revision	E		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	2/28/2008	Qty:	12 Um: Each
Previous Run	36323					
Written By	<i>JL</i>					
Checked & Approved By	<i>JL</i> 08/02/07					
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>3288</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>3288</u> Double check by: <u>SD</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37283

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EG 08.03.03

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BK 08.03.03

(12)

7.0 POWDER COATING POWDER COATING



m 107005

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FD 08/03/04 (12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(12X)

Comment: INSPECT POWDER COAT

m-f

08/03/04

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 422

8/3/05 54

(12X)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/06

Job Completion



m 2008/3/05

(12)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37283
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.442	442	442	442		
B	1.745	1.755	1.750	1.750	1.750	1.750	1.750		
C	3.495	3.505	3.498	3.498	3.500	3.500	3.500		
D	1.745	1.755	1.750	1.750	1.750	1.750	1.750		
E	7.990	8.010	8.000	8.005	8.006	8.004	8.004		
F	0.490	0.510	0.500	0.502	493	494	494		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510	0.501	0.500	0.500	0.501	0.501		
J	1.174	1.184	1.179	1.180	1.180	1.180	1.180		
K	0.558	0.578	0.570	0.568	0.570	0.571	0.571		
L	1.174	1.184	1.179	1.180	1.180	1.180	1.180		
M	1.490	1.500	1.496	1.496	1.496	1.496	1.496		
N	2.495	2.505	2.499	2.500	2.506	2.500	2.500		
O	3.869	3.879	3.873	3.874	3.874	3.874	3.874		
P	0.115	0.135	0.125	0.126	0.123	0.123	0.123		
Q	0.115	0.135	0.135	0.135	0.135	0.135	0.135		
R	0.240	0.260	0.250	0.251	0.249	0.250	0.250		
S	0.115	0.135	0.135	0.126	0.127	0.126	0.126		
T	0.178	0.198	0.188	0.188	0.188	0.188	0.188		
U	2.940	2.980	2.958	2.960	2.960	2.960	2.960		
V	0.230	0.250	0.238	0.233	0.235	0.238	0.238		
W	0.115	0.135	0.122	0.126	0.124	0.123	0.123		
X	0.307	0.312	0.310	0.308	0.310	0.310	0.310		
Y	0.760	0.765	0.762	0.762	0.762	0.762	0.762		
Z	0.352	0.372	0.371	0.362	0.366	0.365	0.365		
AA	0.470	0.530	0.500	0.500	0.500	0.500	0.500		
AB	0.615	0.635	0.625	0.630	0.631	0.631	0.631		
AC	0.053	0.073	0.063	0.063	0.063	0.063	0.063		
AD	0.240	0.260	0.245	0.244	0.245	0.245	0.245		
AE	1.375	1.395	1.387	1.388	1.387	1.388	1.388		
AF	0.115	0.135	0.135	0.135	0.135	0.135	0.135		
AG	0.240	0.280	0.256	0.259	0.250	0.255	0.255		
AH	0.240	0.260	0.247	0.243	0.245	0.248	0.248		
AI	2.000	2.020	2.000	2.001	2.000	2.001	2.001		
AJ	0.023	0.043	0.030	0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: *Amber / SA*
 Date: *02/02/28*

Audited by: *EG*
 Date: *08-03-03*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:	37283
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

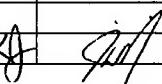
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				1	2	3	4		
A	0.438	0.443	DT8682	.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.756	1.756	1.756	1.756		
E	7.990	8.010		8.003	8.003	8.003	8.002		
F	0.490	0.510		.493	.493	.494	.507		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.378		
I	0.490	0.510		.502	.502	.501	.501		
J	1.174	1.184		1.173	1.173	1.173	1.173		
K	0.558	0.578		.574	.574	.575	.570		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.877	3.877	3.874	3.871		
P	0.115	0.135		.123	.123	.123	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.124	.125	.124	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		.238	.238	.235	.239		
W	0.115	0.135		.120	.121	.121	.126		
X	0.307	0.312		.307	.305	.309	.304		
Y	0.760	0.765		.762	.762	.769	.766		
Z	0.352	0.372		.367	.367	.367	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.240	.240		
AE	1.375	1.395		1.388	1.388	1.387	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.255	.255	.250		
AH	0.240	0.260		.250	.250	.250	.245		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.031	.030	.033	.033		

Accept/Reject

Measured by:  Jmk
Date: 08/02/28

Audited by: 
Date: 08-03-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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B	1.745	1.755		1.750	1.750	1.750	1.750		
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.504	.507	.502	.500		
G	0.257	0.262	DT8683	.258	.259	.259	.259		
H	0.375	0.380	DT8684	.377	.378	.378	.378		
I	0.490	0.510		.506	0.506	.506	.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.570	0.570	0.568	0.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.493	1.494	1.494	1.494		
N	2.495	2.505		2.506	2.506	2.500	2.506		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		.123	.123	.124	.123		
Q	0.115	0.135		.135	0.135	.135	.135		
R	0.240	0.260		.250	0.249	.250	.249		
S	0.115	0.135		.118	0.126	.126	.124		
T	0.178	0.198		.188	0.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.959		
V	0.230	0.250		.238	0.238	.236	.234		
W	0.115	0.135		.125	.120	.124	.124		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.366	.366	.362	.362		
AA	0.470	0.530		.500	0.500	.500	.500		
AB	0.615	0.635		.625	.628	.627	.629		
AC	0.053	0.073		.063	0.063	.063	.063		
AD	0.240	0.260		.241	0.247	.246	.244		
AE	1.375	1.395		1.390	1.390	1.386	1.387		
AF	0.115	0.135		.135	0.135	.135	.135		
AG	0.240	0.280		.250	0.250	.244	.245		
AH	0.240	0.260		.246	0.247	.244	.244		
AI	2.000	2.020		2.002	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>JW</i>	Audited by:	<i>EG</i>
Date:	08/03/01	Date:	08.03.01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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